

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023287**Date Inspected:** 28-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Geng Wei		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Bridge No: 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

Trial Assembly / OBG segment 13AE

This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as OBG 13AE welds as per ZPMC notification # 08973.

The weld designations reviewed are as follows:

SEG3007B-139~142

SEG3007D-225, 228, 231, 233

SEG3007F-004~006, 009

Trial Assembly / OBG segment 13AE

This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as OBG 13AE welds as per ZPMC notification # 08974.

The weld designations reviewed are as follows:

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SEG3007AB-003, 004

Trial Assembly / OBG segment 13AE – 13BE

This QA Inspector observed the following work in progress:

ZPMC personnel performing fit up and tack welding of OBG 13AE and 13BE Cross Beam side SP to SP weld.

Quality Control (QC) is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1. See attached photograph Pic_001.

Trial Assembly / OBG segment 13BE

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4F position of weld # SEG3009L-240. The welder is identified as 067571. Quality Control (QC) is identified as Wang Xu. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1.

Trial Assembly / OBG segment 13CE

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of repair weld # VP3007-001-028, as per B-WR # 20767.

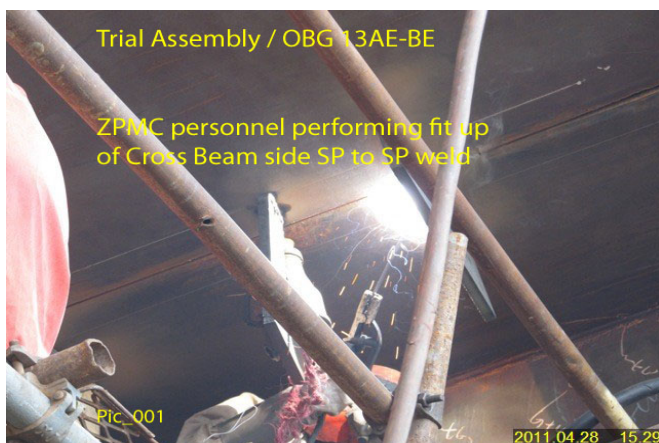
The welder is identified as 058102. Quality Control (QC) is identified as Wang Xu. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-FCM-Repair.

Trial Assembly / OBG segment 13AE

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of weld # SEG3007E-070. The welder is identified as 200113.

Quality Control (QC) is identified as Wang Xu. The welding variables recorded by QC appeared to comply with WPS- B-T-2232-ESAB.



Summary of Conversations:

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No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey (+86) 15000026784 , who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
